

Date: Thursday, 17/04/2008 10:59:11 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 38654
 Estimate Number : 10531
 P.O. Number :
 This Issue : 17/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 37922
 Written By :
 Checked & Approved By : JLP 08/04/17
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ
 Part Number : D2572
 Drawing Number : D2572 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 01/05/2008 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B34874

85 08/05/05

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 8F Double check by: JL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

(P10) →

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



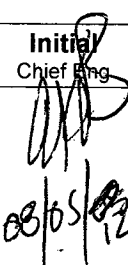

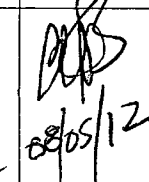
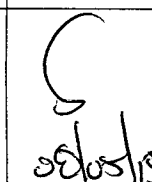
Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

DIP 08/05/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: NA Fault Category: Prod / Machine ^{PAS} NCR: Yes No DQA: 1 Date: 08/05/12
 QA: N/C Closed: 1 Date: 08/05/16

NCR: 38654		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/12	# 30	one saddle scrapers due to machinist not tightening the "Y" pins on the man manual milk after to clay a fine of adjustment.	 08/05/12	Scrap and Destroy and repl replace. Inform senior machinist to Re Recheck all set of screw machinist Batch <u>34874</u>	DJP 08/05/12	 08/05/12	 08/05/12	 08/05/12

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 38654

Part Number: D2572

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DP 08/05/06

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/05/14

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

AD/M-1 08/05

30 min
15/05/2008
S.248 11.59
#1 318.8 F
#2 B 38654 F
#3 B 38654 F
#4 D 2572 F

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107925

M-1 08/05

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

SA 08-05-15

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST 432*

DS 08/05/15 (x8)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/16

Job Completion



MF 08-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38654
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	.443	.443	.443		
B	1.745	1.755		1.748	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	7.998	8.002		
F	0.490	0.510		0.498	.502	.495	0.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		0.499	.502	.503	.505		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		0.5645	.574	.575	.575		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.873		
P	0.115	0.135		.120	.124	.124	.122		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		.251	.248	.249	.249		
S	0.115	0.135		0.124	.123	.125	.123		
T	0.178	0.198		.188	.184	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.961		
V	0.230	0.250		0.232	.238	.240	.237		
W	0.115	0.135		0.133	.135	0.135	0.126		
X	0.307	0.312		.312	.312	.312	0.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.364	.368	.368	0.372		
AA	0.470	0.530		.520	.500	.500	.500		
AB	0.615	0.635		0.6215	.625	.625	0.620		
AC	0.053	0.073		0.0625	.062	.062	0.0625		
AD	0.240	0.260		0.244	.250	.250	.251		
AE	1.375	1.395		1.392	1.385	1.384	1.385		
AF	0.115	0.135		0.135	.135	.125	0.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		0.243	.249	.249	.250		
AI	2.000	2.020		2.008	2.001	2.003	2.003		
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by:	SB / DIP
Date:	08/05/06 / 08/05/06

Audited by:	SA
Date:	08/05/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38654
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

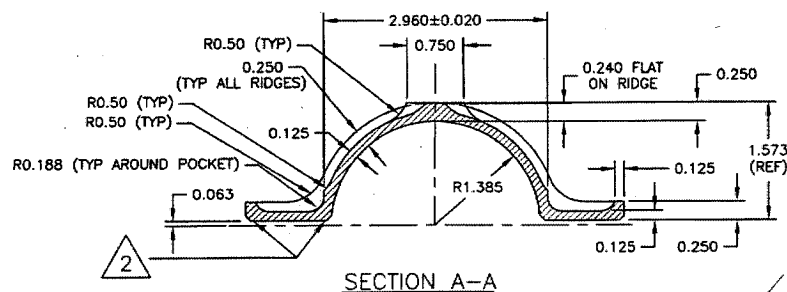
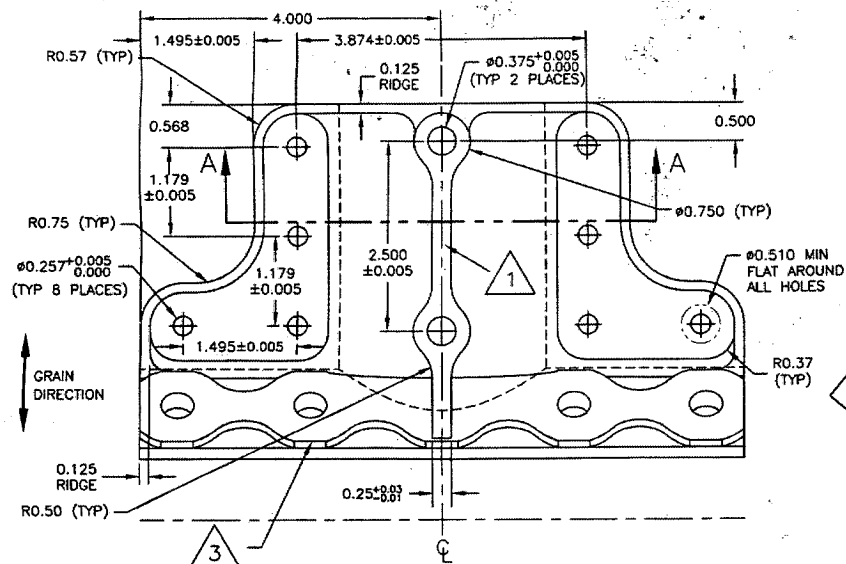
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	ST	62	73	84	By	Date
A	0.438	0.443		.443	.443	.443	0.443		
B	1.745	1.755		1.748	1.749	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.500	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.497	0.501	0.5015	0.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.378	.375	.375	.375		
I	0.490	0.510		.505	.505	0.502	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.575	.575	0.572	0.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
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Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.250	.251	.250	.251		
S	0.115	0.135		.122	.125	0.125	0.122		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.963	2.963	2.962		
V	0.230	0.250		.245	.238	.238	0.230		
W	0.115	0.135		0.125	0.124	0.123	0.123		
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		0.370	0.369	0.369	0.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.623	0.623	0.623	0.624		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		.250	.250	.250	0.243		
AE	1.375	1.395		1.383	1.383	1.384	1.389		
AF	0.115	0.135		.125	0.135	0.135	0.135		
AG	0.240	0.280		.280	.260	.265	.265		
AH	0.240	0.260		.250	.250	0.246	0.243		
AI	2.000	2.020		2.005	2.005	2.005	2.003		
AJ	0.023	0.043							
Accept/Reject									

Measured by: 84
Date: 08/05/08

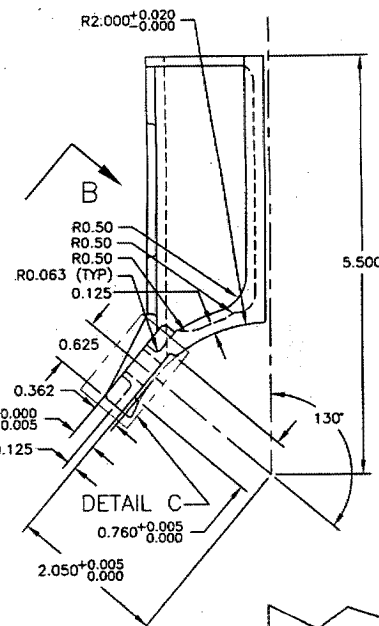
Audited by: SA
Date: 08/05/14

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D	05.05.05	Added dimension AI	KJ/RF	
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05.12.06








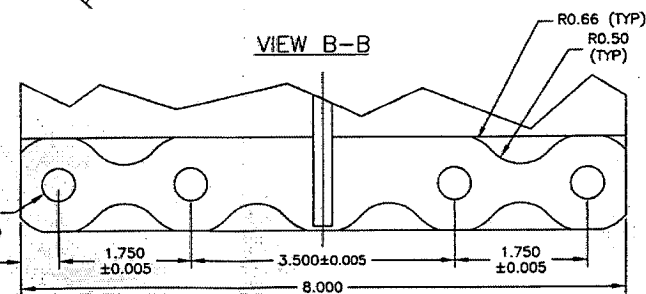
DETAIL C
SCALE 2:1



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)  |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD. SADDLE SHOP COPY SCALE SHEET 1 OF 2

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38654

